

# Work Order ID 74030

Tuesday, September 20, 2011 12:27:59 PM



Ship - 2011 Eagle

Page 1

Item ID: D412-706-011

Accept



Setup Start



Revision ID:

Item Name: Fuel Purge Canister

Stop



Start Date: 9/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: *11-09-10*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9494

A

IIN-D412-706

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-706-011 CHG003

*5/10/05*

*11-9-21*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*11/5/21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 74030**

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Tuesday, September 20, 2011 12:28:00 PM

Item ID: D412-706-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Purge Canister

Start Date: 9/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC4- 100% Inspect kits for completeness

0.00



0.00

Sulcolos

QC

Memo

Quality Control



130

Packaging

0.00



0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPPD412-706-011

Location: 3E  
PPP Rev: E

11/10/5

140

QC21- Final Inspection - Work Order Release

0.00



0.00

QC

Memo

Quality Control

11/10/5  
ME  
11-10-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, September 20, 2011 12:27:49 PM

Page 1

Work Order ID: 74030

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister



Start Date: 9/20/2011

Required Date: 9/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of 924-6D□KJ/JLM  
REV: IPP  
IPP Rev:F 08-05-14 revise comment in seq.17 /24 DD verified by:EC IPP rev G  
10.01.18 per DSI9494 EC verified by:DD IPP Rev:H 10.03.23  
as per IIN revA DD verified by:EC IPP Rev:I 10.05.10 as per chg003 DD verified :EC IPP REV K 11.06.17 AS PER CHG  
002 JLM VERIFIED BY:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2001-4  Valve Assembly (1/4")		Manufactured	No			110	Each	2.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST002				2					
				73083				2		73083			
D3262-043  Canister Assembly		Manufactured	No			110	Each	0.0000	1	1			
D3264-1  Bracket		Manufactured	No			110	Each	3.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST144				3					
				73086				3		73086			
D3297-1-0098  HOSE ASS'Y		Manufactured	No			110	Each	4.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST194				4					
				73087				4		73087			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 74030

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 9/20/2011

Required Date: 9/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3297-3-0085

Manufactured No

110

Each

4.0000

1

1



HOSE ASS'Y

Location

Loc Qty

Loc Code

ST194

4

73088

4

110

Each

4.0000

1

D3297-3-0210

Manufactured No



HOSE ASS'Y

Location

Loc Qty

Loc Code

ST194

4

73089

4

110

Each

0.0000

1

D4054-001

Manufactured No



Tube Assembly

D4054-003

Manufactured No



Tube Assembly

D3298-005

Manufactured No



Tube Assembly

Location

Loc Qty

Loc Code

ST195

4

48509

1

55527

3

110

Each

0.0000

1

D3298-007

Manufactured No



Tube Assembly

73088

73089

73097

73098

73009

73090

*[Handwritten signatures and initials]*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 74030

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 9/20/2011

Required Date: 9/28/2011

Start Qty: 1.00

Required Qty: 1.00

D4054-009

Manufactured No

110

Each

4.0000

1

1



Tube Assembly

Location

Loc Qty

Loc Code

ST193

4

70258

2

73075

2

D3299-7

Manufactured No

110

Each

0.0000

1



Fitting

D3299-3

Manufactured No

110

Each

6.0000

1



Fitting

Location

Loc Qty

Loc Code

ST046

6

55530

6

D3299-5

Manufactured No

110

Each

7.0000

1



Fitting

Location

Loc Qty

Loc Code

ST047

7

43657

1

55531

6

D3301-1

Manufactured No

110

Each

9.0000

1



Placard

Location

Loc Qty

Loc Code

ST047

3

56685

3

ST050

6

73092

6

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Page 3

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 74030

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 9/20/2011

Required Date: 9/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3301-3

Manufactured No

110

Each

7.0000

1

1



Placard



*Handwritten signature*

Location

Loc Qty

Loc Code

ST

6

73093

6

ST047

1

60250

1

60250

D3302-1

Manufactured No

110

Each

11.0000

1

1



Doubler



*Handwritten signature*

Location

Loc Qty

Loc Code

ST143

11

70615

4

73094

7

70615

D3302-3

Manufactured No

110

Each

9.0000

1

1



Doubler



*Handwritten signature*

Location

Loc Qty

Loc Code

ST143

9

70616

2

73095

7

70616

D3329-1

Manufactured No

110

Each

17.0000

2

2



Bushing



*Handwritten signature*

Location

Loc Qty

Loc Code

ST048

17

70257

2

73096

15

70257

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, September 20, 2011 12:27:51 PM

Work Order ID: 74030

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 9/20/2011

Required Date: 9/28/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-5A

Purchased

No

110

Each

902.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST350

902

115371

46

117423

556

118626

300

117423

AN814-8D

Purchased

No

110

Each

2.0000

1

1



Plug

Location

Loc Qty

Loc Code

ST329

2

117967

2

117967

AN815-6D

Purchased

No

110

Each

13.0000

2

2



Union-M-Flare

Location

Loc Qty

Loc Code

ST329

13

118090

13

118090

AN815-8D

Purchased

No

110

Each

6.0000

1

1



Union-M-Flare

Location

Loc Qty

Loc Code

ST329

6

114544

2

118840

4

1114544

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 74030

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 9/20/2011

Required Date: 9/28/2011

Start Qty: 1.00

Required Qty: 1.00

AN924-8D  
NUT

Purchased No

110 Each

4.0000

1

12

Location

Loc Qty

Loc Code

MEZZ

2

114544

2

ST335

2

118838

2

114544

AN938-6D

Purchased No

110 Each

5.0000

1

1

Tee

Location

Loc Qty

Loc Code

ST336

5

101925

5

101925

AN960JD10L NAS1149D0332J

Purchased No

110 Each

0.0000

4

4

Washer

AN960JD10 NAS1149D0363J

Purchased No

110 Each

0.0000

8

8

Washer

AN960JD916 NAS1149D0963J

Purchased No

110 Each

0.0000

2

2

WASHER

117087

118077

116683

9/22

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, September 20, 2011 12:27:51 PM

Page 8

Work Order ID: 74030

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 9/20/2011

Required Date: 9/28/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

2,592.000

4

4

-



Nut

Location

Loc Qty

Loc Code

ST300

2592

117441

24

117601

363

117885

205

118451

1000

118927

1000

1117601

MS21919-WDG9

Purchased

No

110

Each

341.0000

2

2

-



Clamp

Location

Loc Qty

Loc Code

ST307

141

118354

22

118406

69

118686

50

ST309

200

118455

200

118354

MS21920-42

Purchased

No

110

Each

6.0000

2

2

-



CLAMP(per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

ST451

6

118782

6

118782

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, September 20, 2011 12:27:51 PM

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Work Order ID: 74030

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 9/20/2011

Required Date: 9/28/2011

Start Qty: 1.00

Required Qty: 1.00

MS29512-06

Purchased

No

110

Each

3.0000

7

7



O-RING



1109022 4x

Location

Loc Qty

Loc Code

ST294

3

118543

3

118543 3x

MS29512-08

Purchased

No

110

Each

8.0000

3

3



O-RING



Location

Loc Qty

Loc Code

ST294

8

113706

1

117962

7

117962

MS35489-16

Purchased

No

110

Each

22.0000

1

1



GROMMET



Location

Loc Qty

Loc Code

ST295

22

118006

22

118006

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-706 REV. A AND ICA-D412-706 REV. 0

REF TCCA STC: SH04-54  
REF FAA STC: SR02055NY  
REF. EASA STC: EASA.IM.R.S.01180

**REFERENCE ONLY**

**DESCRIPTION:**





AT CHG 002, THE D412-706-011 FUEL PURGE CANISTER INSTALLATION HAS BEEN MODIFIED WITH LARGER VENT LINES TO ELIMINATE BACK PRESSURE THAT MAY OCCUR WHEN STARTING THE SECOND ENGINE IF THE CANISTER HAS NOT BEEN PROPERLY DRAINED. THE BACK PRESSURE IS EVIDENCED BY AN ONGOING VAPOR DISCHARGE FROM THE CANISTER VENT AT LOW TO MEDIUM RPM WHILE STARTING THE 2nd ENGINE. THE UPDATED PARTS LIST IS SHOWN BELOW:

**IS**

QTY -011	PART NUMBER	DESCRIPTION
X	D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
1	D2001-4	VALVE ASSEMBLY
1	D3262-043	CANISTER ASSEMBLY (WAS D3262-041)
2	D3264-1	BRACKET
1	D3297-1-0098	HOSE ASSEMBLY
1	D3297-3-0085	HOSE ASSEMBLY
1	D3297-3-0210	HOSE ASSEMBLY
1	D4054-001	TUBE ASSEMBLY (WAS D3298-001)
1	D4054-003	TUBE ASSEMBLY (WAS D3298-003)
1	D3298-005	TUBE ASSEMBLY
1	D3298-007	TUBE ASSEMBLY
1	D4054-009	TUBE ASSEMBLY (WAS D3298-009)
1	D3299-7	FITTING (WAS 3299-1)
1	D3299-3	FITTING
1	D3299-5	FITTING
1	D3301-1	PLACARD
1	D3301-3	PLACARD
1	D3302-1	DOUBLER
1	D3302-3	DOUBLER
2	D3329-1	BUSHING

Continue on next sheet

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
<b>APPROVED</b>	
BY:  D. SHEPHERD (DE # 02)	
DATE:	11.06.06
CERT. NO.:	SH04-54
ISSUE NO.:	1

B	SHEET 2: D412-706-011 KIT: QTY(7) MS29512-06 WAS QTY(8), QTY(3) MS29512-08 WAS QTY(2), MS35489-16 WAS MS35489-11; DSI 9494-011 KIT P/L: ADDED AN814-8D PLUG AND MS35489-16 GROMMET, QTY(3) MS29512-08 O-RING WAS QTY(2). SHEET 3: AN814-8D PLUG WAS AN814-6D PLUG AND MS29512-08 WAS MS29512-06. REASON: NCR11-641.	MB	11.06.03
A	NEW ISSUE	RF	10.01.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9494	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		212/412 CANISTER UPGRADE KIT NTS	
DATE	11.06.03		
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REFERENCE ONLY

Continue from previous sheet


B	4	AN3-5A	BOLT
	1	AN814-8D	PLUG
	2	AN815-6D	UNION
	1	AN815-8D	UNION (WAS AN815-6D)
	1	AN832-6D	UNION
	1	AN833-6D	ELBOW
	1	AN833-8D	ELBOW (WAS AN833-6D)
	4	AN924-6D	NUT
	1	AN924-8D	NUT (WAS AN924-6D)
	1	AN938-6D	TEE
B	4	AN960JD10L	WASHER (OR NAS1149D0332J)
	8	AN960JD10	WASHER (OR NAS1149D0363J)
	2	AN960JD916	WASHER
	4	MS21042L3	NUT
	2	MS21919WDG9	CLAMP
	2	MS21920-42	CLAMP
	7	MS29512-06	O-RING (WAS MS28778-6)
	3	MS29512-08	O-RING (WAS MS28778-8)
	1	MS35489-16	GROMMET





FOR CUSTOMERS WHO HAVE EXPERIENCED THIS PROBLEM IN SERVICE, THE DSI 9494-011 UPGRADE KIT IS AVAILABLE TO UPGRADE THE INSTALLATION FROM CHG 001 TO CHG 002.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9494-011	212/412 CANISTER UPGRADE KIT
1	D3262-043	CANISTER ASSEMBLY
1	D4054-001	TUBE ASSEMBLY
1	D4054-003	TUBE ASSEMBLY
1	D4054-009	TUBE ASSEMBLY
1	D3299-7	FITTING
B	1	AN814-8D
	1	AN815-8D
	1	AN833-8D
	1	AN924-8D
B	3	MS29512-08
	1	MS35489-16

**WEIGHT AND BALANCE:**  
NO CHANGE

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY:   
D. SHEPHERD (DE # 02)  
DATE: 11.06.06  
CERT. NO.: SH04-54  
ISSUE NO.: 1

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	U/A	DSI 9494	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		212/412 CANISTER UPGRADE KIT	NTS
DATE	11.06.03	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	